

Work Order ID 64756

Thursday, December 16, 2010 9:49:04 AM

Page 1

Item ID: D2344

Revision ID:

Item Name: Litter Deck Plate, 350

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 12/21/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: *PL*Date: *10-12-14*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2344

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

*18-10-12-16**6*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

18-10-12-16

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*8.10.12/16**46*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64756

Thursday, December 16, 2010 9:49:04 AM



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Item ID: D2344	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Litter Deck Plate, 350				
Start Date: 12/16/2010	Start Qty: 6.00		Cust Item ID:	
Required Date: 12/21/2010	Req'd Qty: 6.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Deburr sharp edges □2-Countersink holes per Dwg D2344								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten: 12/17/17 (6)

Handwritten: 10/12/17

Handwritten: (X6)

Handwritten: 10/12/20

Handwritten: X6 0

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 64756

Thursday, December 16, 2010 9:49:04 AM

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Item ID: D2344

Accept

Setup Start

Revision ID:

Stop

Item Name: Litter Deck Plate, 350

Start Date: 12/16/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 12/21/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/21
MF
10-12-21

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, December 16, 2010 9:49:09 AM

Page 1

Work Order ID: 64756



Parent Item: D2344



Parent Item Name: Litter Deck Plate, 350

Start Date: 12/16/2010

Required Date: 12/21/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:D 00.06.26 Removed P/O for powder coat EC
IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	78.5000	0.745	4.705263			



2024-T3 .063 sheet



1810-12-16

Location

Loc Qty

Loc Code

MAT22

78.5

114351

78.5

114351

(6)

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DART AEROSPACE LTD		Work Order:	44754
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.229	✓		✓ B02	
5.598	+/-0.010	5.594	✓		✓	
4.869	+/-0.010	4.865	✓		✓	
3.889	+/-0.010	3.889	✓		✓	
3.096	+/-0.010	3.098	✓		✓	
2.891	+/-0.010	2.890	✓		✓	
16.973	+/-0.010	16.973	✓		✓ B01	
0.450	+/-0.010	.447	✓		✓	
4.423	+/-0.010	4.426	✓		✓	
4.723	+/-0.010	4.724	✓		✓	
1.202	+/-0.010	1.201	✓		✓	
5.869	+/-0.010	5.870	✓		✓	
4.654	+/-0.010	4.656	✓		✓	
Ø0.656	+0.005/-0.000	.656	✓		✓	
1.888	+/-0.010	1.887	✓		✓	
2.285	+/-0.010	2.287	✓		✓	
2.683	+/-0.010	2.683	✓		✓	
Ø0.171	+0.005/-0.000	.171	✓		✓	
3.491	+/-0.010	3.494	✓		✓	
Ø0.191	+0.005/-0.000	.191	✓		✓	
3.123	+/-0.010	3.127	✓		✓	
1.975	+/-0.010	1.977	✓		✓	
Ø0.128	+0.005/-0.001	.129	✓		✓	

Measured by: B	Audited by: J	Prototype Approval:	N/A
Date: 10-12-16	Date: 10/12/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	B

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